

Claims:

1. A method for producing cardboard matches, especially for books of matches, comprising the following production steps:
 - cutting or punching at least one piece of cardboard (1) from a particularly paper- or cardboard-like material in such a way that for forming individual adjacent strips (5) cuts (4) are made in the piece of cardboard (1) from a first transversal side (3);
 - providing at least end sections (7) of the strips (4) with preferably paraffin and an igniting composition (9) to form match strips;
characterized in that
 - in addition cuts (4) are made in the piece of cardboard (1) from a second transversal side (3), which is substantially opposite of the first side, in order to form further strips (5).
2. A method for producing cardboard matches as claimed in claim 1, characterized in that the formation of the second strips (5) is performed in the same production step as the formation of the first strips (5).
3. A method for producing cardboard matches as claimed in claim 1 or 2, characterized in that the piece of cardboard (1) is provided with an oblong shape, with the longitudinal extension of the piece of cardboard (1) being produced in particular nearly twice as long as its transversal extension.
4. A method for producing cardboard matches as claimed in claim 3, characterized in that the length of the cuts (4) towards the center of the piece of cardboard (1) is provided by slightly more than one third of the length of the longitudinal sides (2).
5. A method for producing cardboard matches as claimed in one of the preceding claims, characterized in that a first section extending from the first transversal side (3) of the piece of cardboard (1) is bent or folded, so that the first transversal side (3) comes to lie preferably behind the second transversal side (3) or adjacent to the same.
6. A method for producing cardboard matches as claimed in claim 5, characterized in that the folded piece of cardboard (1) is fastened in a book of matches by providing a two-layer arrangement of superimposed strips (5).
7. A method for producing cardboard matches as claimed in one of the preceding claims, characterized in that a specially line-shaped weakening zone (6) is integrated in the piece of cardboard (1) approximately centrally between the transversal sides (3) and parallel to the same.
8. A method for producing cardboard matches as claimed in claim 7, characterized in that the weakening zone is a perforation (6) which is preferably simultaneously punched into the same during the punching of the piece of cardboard (1).
9. A method for producing cardboard matches as claimed in one of the preceding claims, characterized in that the zones of the end sections (7) of the two transversal sides (3) arranged in one plane are provided with paraffin and/or

igniting mass.

10. A method for producing cardboard matches as claimed in claim 9, characterized in that the two zones of the end sections (7) are treated successively and that the piece of cardboard (1) is rotated accordingly in between.
11. A method for producing cardboard matches as claimed in one of the claims 1 to 8, characterized in that the piece of cardboard (1) is folded about an angle of preferably more than 90° and less than 180° and the zones of the end sections (7) of the two transversal sides are provided thereafter simultaneously with paraffin and/or igniting mass (9).
12. A method for producing cardboard matches as claimed in one of the preceding claims, characterized in that cuts (4) and/or cutouts (11) between the individual strips (5) are arranged such that the individual strips (5) are differently wide and/or differently shaped.
13. A method for producing cardboard matches as claimed in one of the preceding claims, characterized in that the piece of cardboard (1) is printed before or after the punching or cutting with advertisements or at least a motif (15).
14. A method for producing cardboard matches as claimed in claim 13, characterized in that of the first piece of cardboard (1), the section in the zone of the first transversal side (3) is printed from behind and the section in the zone of the second transversal side (3) is printed from the front.
15. Cardboard matches, in particular for a book of matches, produced in particular according to a method as claimed in one of the preceding claims,
 - of a piece of cardboard (1),
 - with a first and a second, substantially mutually opposite transversal side (3),
 - with cuts (4) which are formed in the first transversal side (3) by forming first strips (5) with end sections (7),
 - with igniting composition (9) and with preferably paraffin on the end sections (7) to form match strips, characterized in that
 - further cuts (4) which are formed in the second transversal side (3) by forming second strips (5) with end sections (7).
16. Cardboard matches as claimed in claim 15, characterized in that the second strips (5) and the first strips (5) are arranged integrally with the piece of cardboard (1).
17. Cardboard matches as claimed in claim 15 or 16, characterized in that the piece of cardboard (1) is provided with an oblong shape, with its longitudinal sides (2) being twice as long as its transversal sides (3).
18. Cardboard matches as claimed in claim 17, characterized in that the length of the cuts (4) leads towards the center of the piece of cardboard (1) by slightly more than one-third of the length of the longitudinal sides (2).
19. Cardboard matches as claimed in one of the claims 15 to 18, characterized in that a first section starting out from the first transversal side (3) of the piece of

cardboard (1) is bent or folded in such a way that the first transversal side (3) preferably comes to lie behind the second transversal side (3) or adjacent to the same.

20. Cardboard matches as claimed in claim 19, characterized in that the folded piece of cardboard (1) is fastened in a book of matches by providing a two-layer arrangement of superimposed strips (5).
21. Cardboard matches as claimed in one of the claims 15 to 20, characterized in that an especially line-shaped weakening zone, preferably a perforation (6), is arranged in the piece of cardboard (1) approximately centrally between the transversal sides (3) and parallel to the same.
22. Cardboard matches as claimed in one of the claims 15 to 21, characterized in that the cuts (4) and/or the cutouts (11) are arranged between individual strips (5) in such a way that the individual strips (5) are shaped with different widths and/or different shapes.
23. Cardboard matches as claimed in one of the claims 15 to 22, characterized in that the piece of cardboard (1) is printed with advertising or at least one motif (15) over a large area and/or strips (5) for strips (5).
24. Cardboard matches as claimed in claim 23, characterized in that of the piece of cardboard (1) the section in the zone of the first transversal side (3) is printed from the back and the section in the zone of the second transversal side (3) is printed from the front.
25. Cardboard matches as claimed in one of the claims 15 to 24, characterized in that the shape of the strips (5) and a printed motif (15) are matched to one another.
26. Cardboard matches as claimed in one of the claims 15 to 25, characterized in that the igniting mass (9) is colored.
27. A book of matches with at least one cardboard match as claimed in one of the claims 15 to 26.